

Date: Wednesday, 15/08/2007 4:00:38 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW
Job Number	: 33944		
Estimate Number	: 12926		
P.C. Number	: N/A	Part Number	: D29381UP
This Issue	: 15/08/2007 S.O. No. : N/A	Drawing Number	: D2938 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: <i>JL 07-08-16</i>	Due Date	: 10/09/2007
Checked & Approved By	:	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 07-07-04 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Issue material from stock: 7075-T7351 (QQ-A-250/12)  
Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length  
(D6101-003) Batch No: *B31387*

*J.L 07/08/20*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program part number and batch number.  
1-Inspect part number and batch number are programmed correctly.  
2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
5-Deburr

*SA/J.L 07/08/23*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine Keyway and inspect per attached dimension sheet

*SA/J.L 07/08/23*

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

*SA/J.L 07/08/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: (D) Date: 07/08/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:00:38 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 33944

Part Number: D29381UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Ant 07/08/23 10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-08-24

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

h

07-08-24

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 445

h

07-08-24

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)

07/08/27

Job Completion



h 07-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description: 206 Saddle, Outboard, Left side</b>	<b>Part Number:</b>	<b>D2938-1</b>
<b>Inspection Dwg: D2938 Rev. C</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.126	.125	.125	.127		
B	0.100	0.140		.128	.126	.123	.126		
C	0.100	0.140		.126	.120	.119	.124		
D	0.210	0.230		.221	.223	.225	.226		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.238	.237	.237		
N	0.100	0.140		.121	.125	.127	.127		
O	0.540	0.560		.550	.550	.558	.550		
P	0.490	0.510		.501	.498	.491	.497		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.254	.249	.251	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.254	1.264	1.267	1.265		
Y	1.565	1.585		1.567	1.576	1.582	1.579		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	J.L. / SA
Date:	07.08.21

Audited by:	SM
Date:	07/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description: 206 Saddle, Outboard, Left side</b>	<b>Part Number:</b>	<b>D2938-1</b>
<b>Inspection Dwg: D2938 Rev. C</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.125	.123	.126		
B	0.100	0.140		.127	.126	.124	.124		
C	0.100	0.140		.122	.121	.120	.122		
D	0.210	0.230		.223	.225	.222	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.239	.239	.239		
N	0.100	0.140		.120	.120	.123	.123		
O	0.540	0.560		.548	.548	.550	.550		
P	0.490	0.510		.497	.498	.501	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.714		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.251	.251	.251		
T	0.100	0.180		.140	.140	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.265	1.265	1.262	1.263		
Y	1.565	1.585		1.577	1.577	1.576	1.571		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>SD/JL</u>
Date: <u>07/08/23</u>

Audited by: <u>Trb</u>
Date: <u>07/08/23</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description: 206 Saddle, Outboard, Left side</b>		<b>Part Number: D2938-1</b>	
<b>Inspection Dwg: D2938 Rev. C</b>		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
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A	0.100	0.140		.125	.122				
B	0.100	0.140		.123	.120				
C	0.100	0.140		.121	.120				
D	0.210	0.230		.220	.222				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.513	.513				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.316	.316				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.123	.124				
O	0.540	0.560		.548	.548				
P	0.490	0.510		.500	.501				
Q	3.715	3.725		3.719	3.720				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		.251	.252				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.629				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.321	.321				
X	1.250	1.270		1.262	1.262				
Y	1.565	1.585		1.575	1.574				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	07/08/23

Audited by:	CM
Date:	07/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
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